

Work Order ID 132166

Wednesday, April 29, 2015 3:02:58 PM

132166

Page 1

Item ID: D3609-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 4/29/2015 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 4/29/2015 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-04-29 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3609	D								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3609								
304.032	Dwg Rev: <u>0</u>								
	Prog Rev: <u>0</u>								
	NO SCRATCH ON TOP SURFACE								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

40 0 Jm15-4-30

40 0 Jm15-4-30

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Item ID: D3609-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Doubler

Stop

NS2

Start Date: 4/29/2015

Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/29/2015

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(10)

38
9-89
APR 30 2015

121

Form as per dwg

0.00

121

Brake NC

Memo

0.00

Brake NC

USE DT9760 TOOL

20

FF

MAY 11 2015

122

0.00

122

Small Fab

Memo

0.00

Small Fab

1- TRIM AS PER DWG USING GUIDE LINES
2- BUFF SCRATCHS WITH LINE MATE (RED SCOTCH BRIGHT) TOP
SURFACE ONLY

20

FF

MAY 11 2015

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Item ID: D3609-1 Accept ***N19000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 4/29/2015 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 4/29/2015 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123 *123* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(20)			38 9-89 MAY 13 2015
130 *130* Packaging Packaging	Identify as per dwg & Stock Location <u>9/22/15</u> Memo	0.00 0.00				20	27 9-89		MAY 13 2015
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MLJ			MAY 15 2015

MLJ MAY 14 2015

Picklist Print

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Work Order ID: 132166

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Parent Item: D3609-1

D3609-1

Parent Item Name: Doubler

Start Date: 4/29/2015

Required Date: 4/29/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC IPP REV:C
AS PER REV C JLM 11-05-04 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S22GA4P

Purchased

No

sf

64.0000

M304S22GA4P

~~18~~
(32)

Jm/5-4-30

304/316 Sheet .032

Location

Loc Qty

Loc Code

MAT020

64

m126571

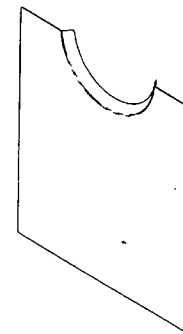
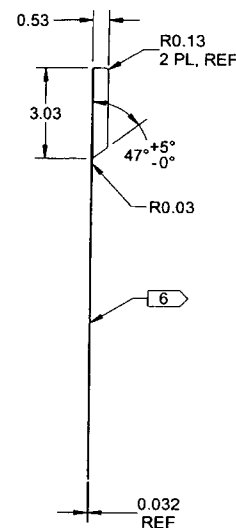
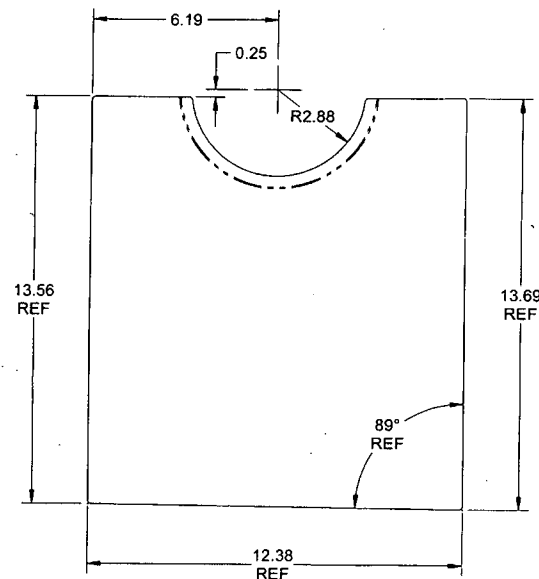
64

126571

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO RE-EXAMINE

NO 132166 MLC

APR 29 2015



D3609-1 DOUBLER

NOTES:

- 1) MATERIAL: MAKE FROM D3609-1F FLAT PATTERN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.46 lbs
- 8) FORM USING DT9763 AND TRIM PER PHANTOM LINE ON SHEET 2

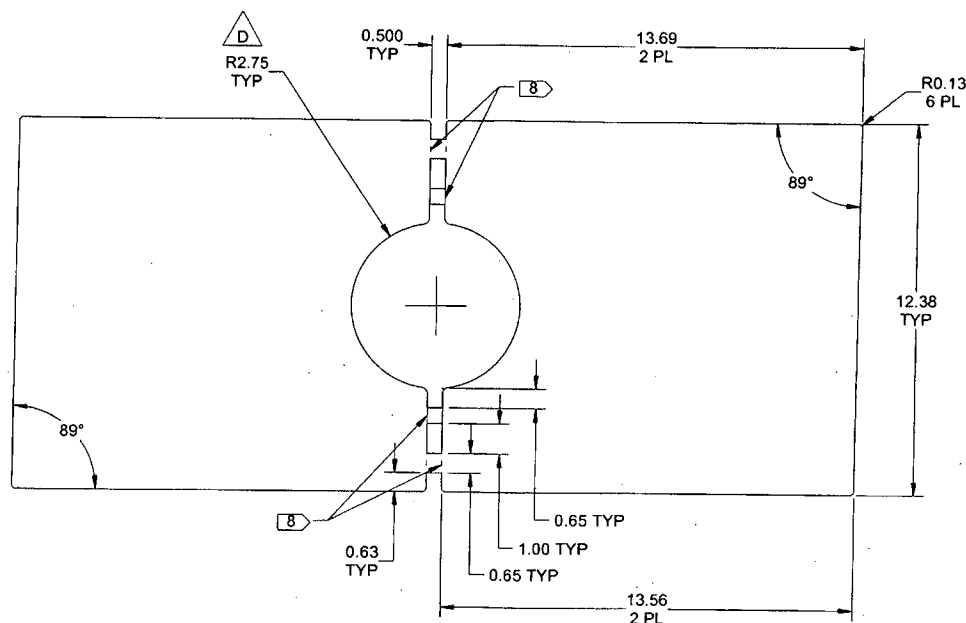
RELEASED
2011-10-04

REV.	DESCRIPTION	BY	DATE
D	REVISE FLAT PATTERN SYMMETRY; R2.75 WAS R2.83 (ZN C6-2)	RF	11.09.20
C	2.88 WAS 2.98 (ZN C5-1); 3.03 WAS 3.20 (ZN C4-1); 0.53 WAS 0.50 (ZN D4-1); ADD ANGLE TOLERANCE (ZNC3-1); REVISE D3609-1F	RF	11.06.07
B	ADD BEVEL (ZN C3-1); ADD FLAT PATTERN (ZN B4-2)	RF	11.04.28
A	NEW ISSUE	MB	07.04.11
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	11.09.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3609** REV. D
SHEET 1 OF 2
TITLE **DOUBLER** SCALE NTS

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NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE
 PER MIL-S-5059
 OR AMS 5513 (304)
 OR AMS 5524 (316)
 OR ASTM 240
 OR ASME SA240
 PER DART SPEC M304S22GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 2.93 lbs

8) FORM USING DT9763 AND TRIM PER PHANTOM LINE

D3609-1F FLAT PATTERN
 (MAKES 2 PARTS)

DESIGN		DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3609	REV. D
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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 2011-10-04